

Work Order ID 62825

Friday, October 08, 2010 12:47:54 PM



Page 1

Item ID: D3518-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: 11Date: 10/10/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3518

Rev B

100

0.00



CONVENTIONAL LATHE

Lathe Conv

Memo

0.00

Conventional Lathe

Turn as per Dwg D3518, □1-Face to Lengh and Drill & Tap.

10/11/10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10/11/10

120

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Drill as per Dwg D3518, □1-Drill 2x .191" holes & 1x .0625" hole

10/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62825

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Page 2

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Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

~~AS~~ 10/11/15

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 10/11/15

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

H BR 10-11-15

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3518-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115291

Memo

0.00

Powder Coating

*****Mask threads with AN6 bolt***** START TIME:
3:15 ☐ OVEN TEMPERATURE: 320 ☐ FINISH
TIME: 3:45

H. CR 10-11-13

170



QC

QC3- Inspect Part Finish

0.00

=> 90 10/11/16

Memo

0.00

Quality Control

4 4

180



Packaging

Identify as per dwg & Stock Location: 271

0.00

Memo

0.00

Packaging

Cep/16 (4)

W/O:		WORK ORDER CHANGES					
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Start Date: 10/8/2010 Start Qty: 4.00

Required Date: 10/15/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

CK 10/11/16 [Signature]
MF
10-11-16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:48:02 PM

Page 1

Work Order ID: 62825



Parent Item: D3518-1



Parent Item Name: Strut


Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-20 JLM
IPP rev B rev B dwg 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6H0.875 		Purchased	No			100	f	24.0000	1.1	4.631579			

6061-T6 HexBar .875

Location

Loc Qty

Loc Code

MAT012

24

110980

24

4.75 *AS* 10/11/10

W/O:		WORK ORDER CHANGES					
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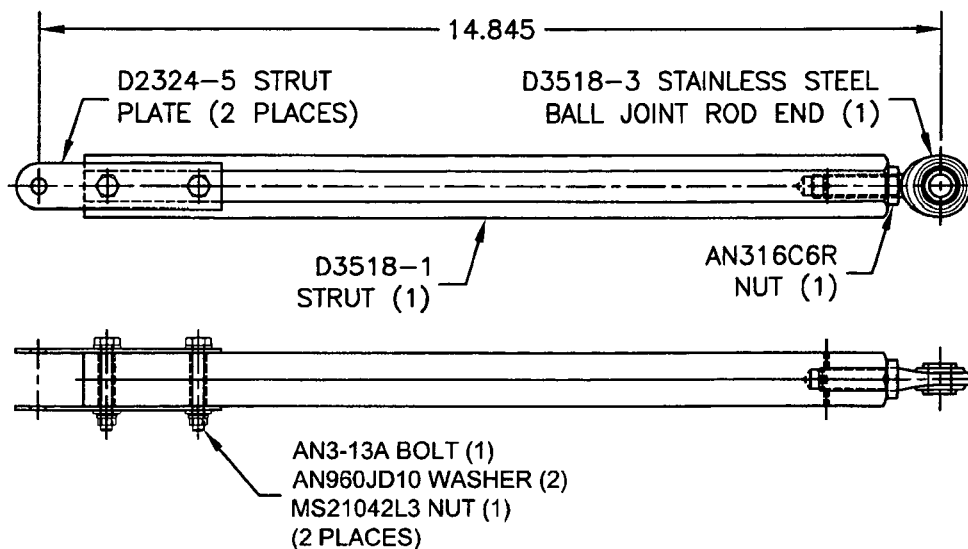
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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 1 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3
A	06.06.21	NEW ISSUE	
B	06.10.23	RE-DESIGN	

**D3518-041 STRUT ASSEMBLY**

QTY -041	Part Number	Description
X	D3518-041	STRUT ASSEMBLY
2	D2324-5	STRUT PLATE
1	D3518-1	STRUT
1	D3518-3	STAINLESS STEEL BALL JOINT ROD END
2	AN3-13A	BOLT
1	AN316C6R	NUT
4	AN960JD10	WASHER
2	MS21042L3	NUT

NOTES:

- 1) IDENTIFY WITH DART P/N "D3518-041" USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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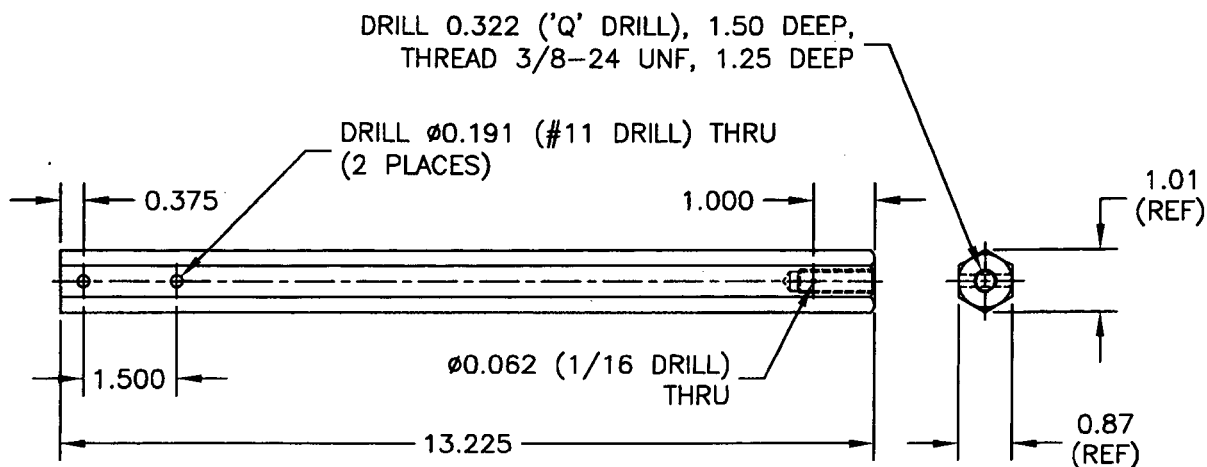
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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 2 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:3

**D3518-1 STRUT****NOTES:**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM HEX BAR PER
AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER
AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6H0.875)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

RELEASED

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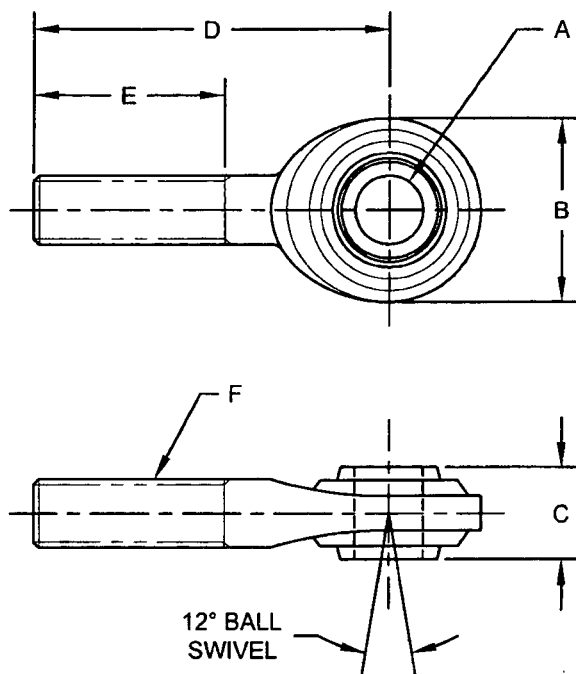
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DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3518	REV. B SHEET 3 OF 3
DATE 06.10.23		TITLE BASKET (A119) STRUT	SCALE 1:1

SPECIFICATION CONTROL DRAWING

*u/b 2825*

DART P/N	A	B	C	D	E	F	LOAD*	POSSIBLE SUPPLIER
D3518-3	0.375	1.00	0.50	1.938	1.25	3/8-24 UNF, RH	4012	McMASTER-CARR, P/N 2458K14

* Indicated load is Static Radial Load Capacity in lbs

NOTES:

- 1) TYPE: MALE THREADED SHANK CARBON-FIBER-REINFORCED PLASTIC RACE BALL JOINT ROD END
- 2) MATERIAL: ZINC PLATED STEEL HOUSING BALL WITH PTFE LUBRICATED CARBON-FIBER-REINFORCED PLASTIC RACE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED*06.11.17*

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